

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014146**Date Inspected:** 08-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Qiu Wen/You Qi Guo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:-

TOWER TRAIL ASSEMBLY AREA:-

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as West Tower Skin B 9M, 13M Exterior diaphragm Connection plate. The weld designations reviewed are as follows:-

WSD1-SA279D/F-10, 11

IN PROCESS INSPECTION:-

TOWER TRAIL ASSEMBLY AREA:-

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: ESD1-A167A/H-8B located on Shearing Splice Plate. Welders are identified as 040367 and 057244. ZPMC QC is identified as Mr. Xing Shi Shun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U5-F.

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: WSD1-A423A/H-3B located on Shearing Splice Plate. Welder is identified as 049270.ZPMC QC is identified as Mr. Xing Shi Shun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: NSD1-A112E/H-251 located on 13M Skin D Exterior Connection Plate. Welder is identified as 500331.ZPMC QC is identified as Mr. Wang Chaung Xin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2212-TC-U4b.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: NSD1-A112E/H-252 located on 13M Skin D Exterior Connection Plate. Welder is identified as 500331.ZPMC QC is identified as Mr. Wang Chaung Xin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2212-TC-U4b.

This QA inspector observed the following work in progress:

SMAW Welding of weld joint no: SD1-SA183-18M-3-1A/B located on Strut Connecting Angle Plate. Welder is identified as 052910. ZPMC CWI is identified as Mr.You Qi Guo. Welding was been performed against Critical Welding Repair Report T-CWR618 and UT report number- T787-UT-2840.The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-1G(1F)-FCM-Repair-1.Please see the attached photo.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.



## Summary of Conversations:

No Relevant Conversation.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

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# WELDING INSPECTION REPORT

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<b>Inspected By:</b>	Pillai, Pandaram	Quality Assurance Inspector
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<b>Reviewed By:</b>	Clifford, William	QA Reviewer
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